

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001492**Date Inspected:** 14-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG U Ribs**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to perform observations of the welding of Orthotropic Box Girder (OBG) Deck Plate Production Monitoring Test (PMT), for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector Viars observed the Production Monitoring Test for Production Panel DP058-001 closed rib welds in Bay #1. ZPMC welding personnel performed Gas Metal Arc (GMAW) for the root pass and Submerged Arc Welding (SAW) for the cover. Dual process WPS-B-T-2342-U1 (U-rib)-3 was posted as the Welding procedure specification for closed rib welding. The following weld joint and welder were recorded for the PMT, weld joint (wj) wj # 1 Mr. Han Chang Hou, wj # 2 Mr. Chen Jie, wj # 3 Mr. Gao Xin Dong, wj # 4 Mr. Jiang Ting Guang, wj # 5 Mr. Zhao Cheng Shuang and wj # 6 Mr. Yuan Fengchuan. ZPMC personnel performed Gas Metal Arc Welding (GMAW) for the first pass and Submerged Arc Welding (SAW) for the second pass.

Caltrans QA representatives Alfredo Acuna, and Larry Viars performed visual inspection of the PMT tack welds, root gap measurements and weld spacing. The joint fit up and tacking welding appeared to be in conformance with the contract documents.

No welding was performed on the Production Panel on this date.

Preheating of the PMT was required to bring the steel temperature to the required 10 degrees Celsius.

Summary of Conversations:

As identified within the contents of this report.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
